

Date: Tuesday, 13/11/2007 3:11:33 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM  
 Job Number : 35660  
 Estimate Number : 10346  
 P.O. Number :  
 This Issue : 13/11/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D2596  
 Drawing Number : D2596 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 First Issue : 13/11/2007 Type : LANDING GEAR Material :  
 Previous Run : 34791 Due Date : 20/11/2007 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D  
 M  
 Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Ext'n -"I" Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Extrusion "I" Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	31223

(4)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

SL 7-11-14 (4)

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

SL 7-11-14 (4)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

DP 7-11-14 (4)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 35660

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP

7-11-121

(4)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.15

Signature

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 07.11.14

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

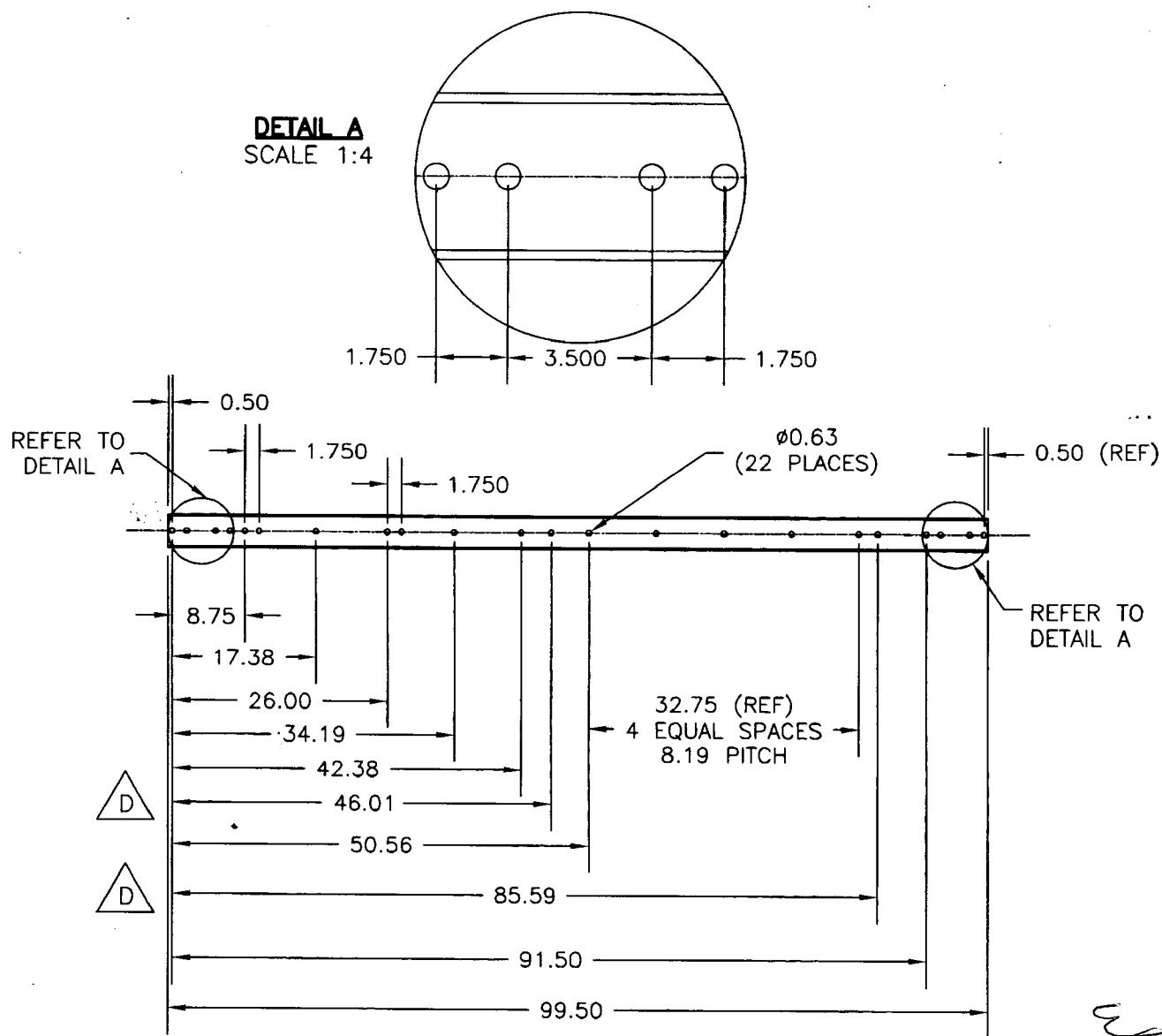
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**DART****RELEASED**  
07 OCT 1987

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. D
CHECKED <i>RA</i>	APPROVED <i>RA</i>	DRAWING NO.	D2596	SHEET 1 OF 1
DATE	07.04.17	TITLE	205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE		
B	97.07.23	Ø0.63 HOLE WAS Ø0.56		
C	98.09.14	INCORPORATED DEO 9097		
D	07.04.17	INCORPORATED DEO 9183		

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries